

Work Order ID 63764

Friday, November 12, 2010 11:59:14 AM



Page 1

LIT.

Item ID: D4278-047
Revision ID: PRELIM
Item Name: Upper Rib Assembly-Straight
Start Date: 11/15/2010 Start Qty: 2.00
Required Date: 11/16/2010 Req'd Qty: 2.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

**PRELIMINARY ISSUE**

Run Start

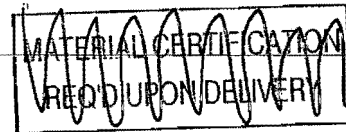


Stop



Approvals: Process Plan: MF Date: 10-11-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____






Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4278	PA1								
100	Weld per dwg A/R S.S. rod Batch: <u>111585</u>	0.00							
Large Fab	Memo	0.00							
Large Fab	1- Assemble bushing and weld as per dwg 2- Grind weld flush as per dwg								
110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									



Pl 10.11.16BE
10.11.162 0SiowleFD



Work Order ID 63764

Friday, November 12, 2010 11:59:14 AM

Page 2

Item ID:	D4278-047	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Upper Rib Assembly-Straight					
Start Date:	11/15/2010	Start Qty:	2.00		Cust Item ID:	
Required Date:	11/16/2010	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo ***STOCK IN BASKET CELL***	0.00 0.00		SAP 10-11-16		<u>2</u>			
140  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

Handwritten: 10.11.22
 POSITIVE RECALL
 EFFECTIVE _____ AUTH _____
 RELEASED _____ DATE _____

Handwritten: MF
 10-11-16

Picklist Print

Friday, November 12, 2010 11:59:13 AM

Page 1

Work Order ID: 63764



Parent Item: D4278-047



Parent Item Name: Upper Rib Assembly-Straight

Start Date: 11/15/2010

Required Date: 11/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9

Manufactured

No

100

Each

22.0000

2

4



Bushing

Location

Loc Qty

Loc Code

WA

22

56094

2

60184

4

60803

16

D4277-1

Manufactured

No

100

Each

0.0000

1

2



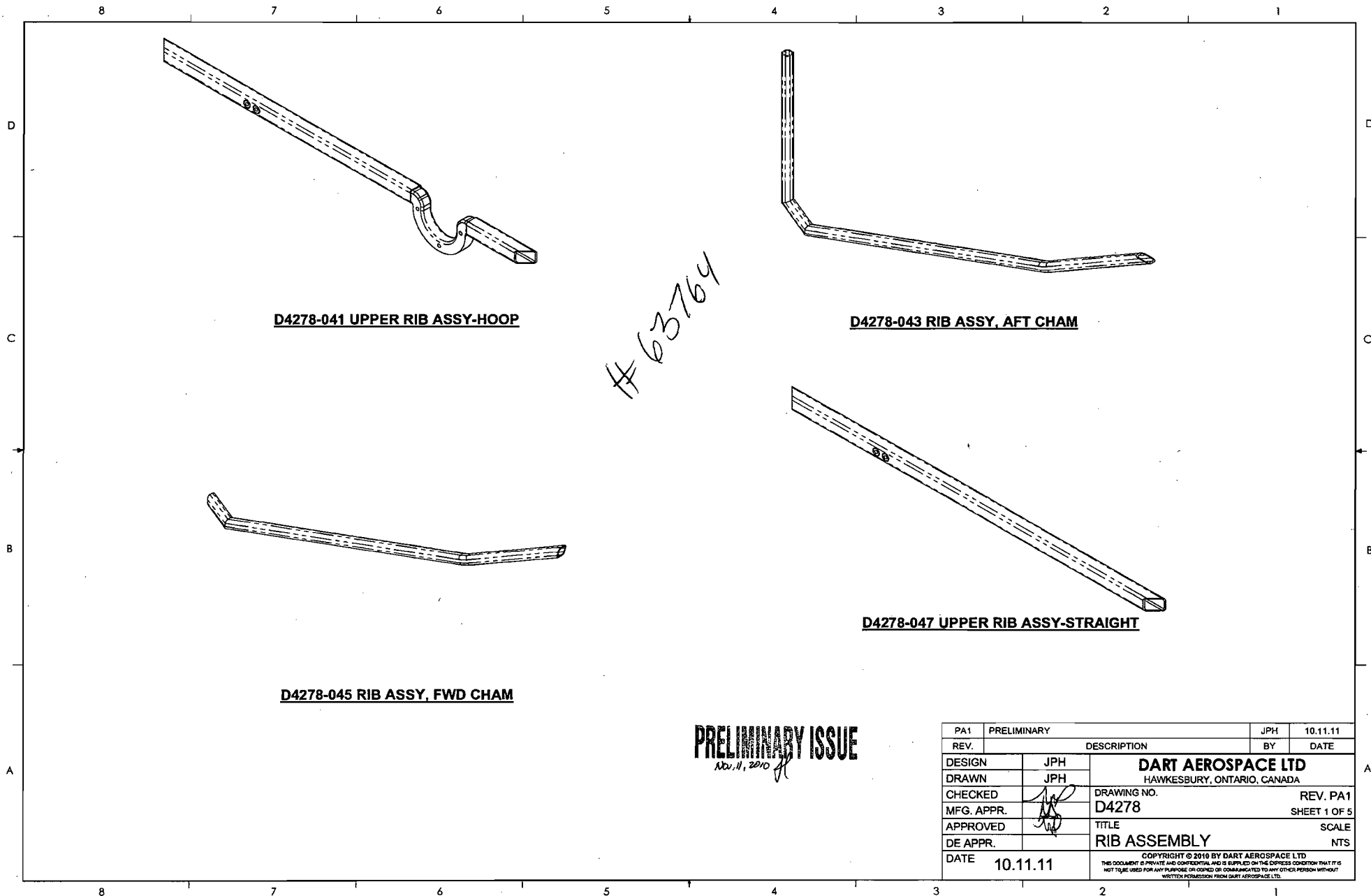
Rib

Pl 10.11.16

23

Pl 10.11.16

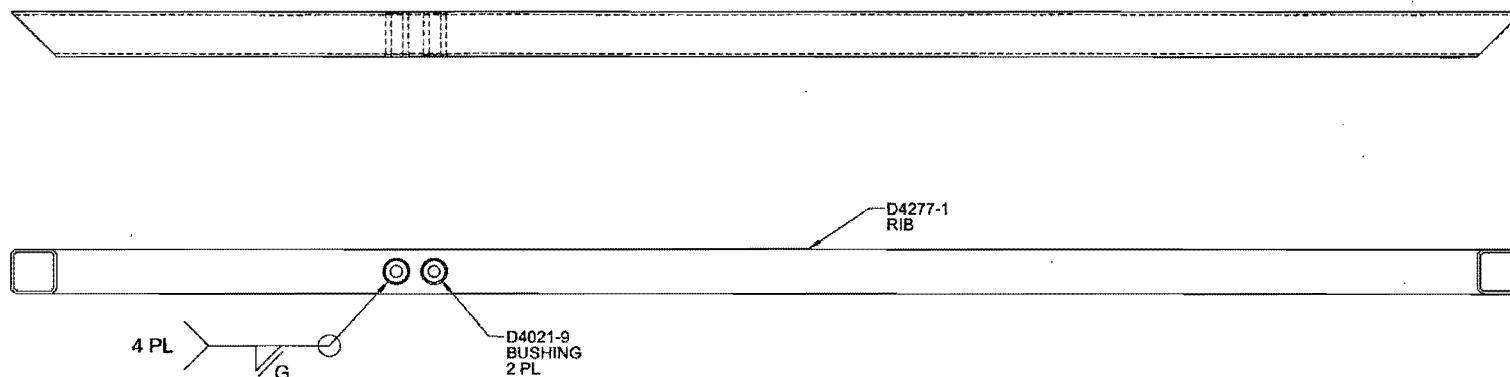
B63778-2



PRELIMINARY ISSUE
Nov. 11, 2010

PA1	PRELIMINARY	JPH	10.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4278	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	10.11.11	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-047	UPPER RIB ASSY-STRAIGHT
1	2	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

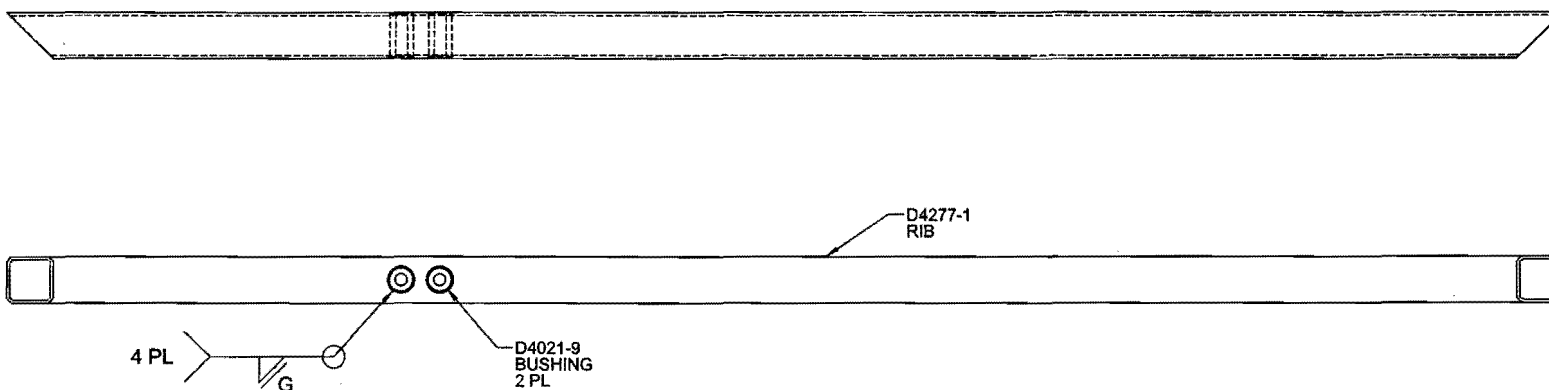
#63764

PRELIMINARY ISSUE
Nov 11, 2010

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.92 lbs
 - 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4278	REV. PA1
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSEMBLY	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.11.11	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	2	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.92 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4278	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
DATE	10.11.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	